

**Work Order ID 66248**

Tuesday, February 08, 2011 9:52:47 AM



Page 1

Item ID: DSK078

Accept



Setup Start



Revision ID:

Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 2/9/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSK078

Rev A

100

0.00



MORI SEIKI CNC LATHE LARGE

11-2-9

10

Doosan

Memo

0.00

Doosan Lathe

Turn blank as per Folio FA081  
(4TH AXIS PLUG DT8492)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

11-2-9

10

QC

Memo

0.00

Quality Control

120

0.00



QC8- Inspect parts - second check

2nd 11/02/09

10

QC

Memo

0.00

Quality Control

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Page 2

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Accept



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Stop



Item Name: D2893-1 TURNING DETAIL

Start Date: 2/9/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/2011 Req'd Qty: 10.00

Customer:

Reference:

*11-02-08*

Run Start



Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and Stock in Kanban Location: *CNC*

140

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*11-2-9**10**11/02/10*  
*mf*  
*11-02-10*

# Picklist Print

Tuesday, February 08, 2011 9:52:43 AM

Page 1

Work Order ID: 66248

Parent Item: DSK078

Parent Item Name: D2893-1 TURNING DETAIL


Start Date: 2/9/2011

Required Date: 2/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP rev A. 08.03.13 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6104-005  Round Billet, 17-4		Manufactured	No				Each	5.0000		10		11.2.9	

Location

MAT

Loc Qty

5

Loc Code

60944 ✓

DS750

5



5

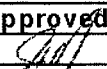
DART AEROSPACE LTD		Work Order: 66248
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
Lathe Section								
A	2.707	2.712		2.709	2.709	2.709	2.709	2.709
B	4.946	4.966		4.956	4.956	4.956	4.956	4.956
C	3.064	3.084		3.074	3.074	3.074	3.074	3.074
D	0.718	0.738		.726	.726	.726	.726	.726
E	0.090	0.110		.100	.100	.100	.100	.100
F	2.934	2.954		2.943	2.943	2.943	2.943	2.943
G	2.166	2.186		2.173	2.173	2.173	2.173	2.173
H	3.890	3.910		3.900	3.900	3.900	3.900	3.900
I	0.914	0.934		.924	.924	.924	.924	.924
J	0.022	0.042		.032	.032	.032	.032	.032
K	0.109	0.129		.117	.117	.117	.117	.117
L								
M								
N								
O								
P								

Measured by: 	Date: 11.2.8
Audited by: 	Date: 11/02/09
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 66248
Description: Turning Detail for D2893-1		Part Number: DSK078
Inspection Dwg: DSK078 Rev: A		Page 1 of 1

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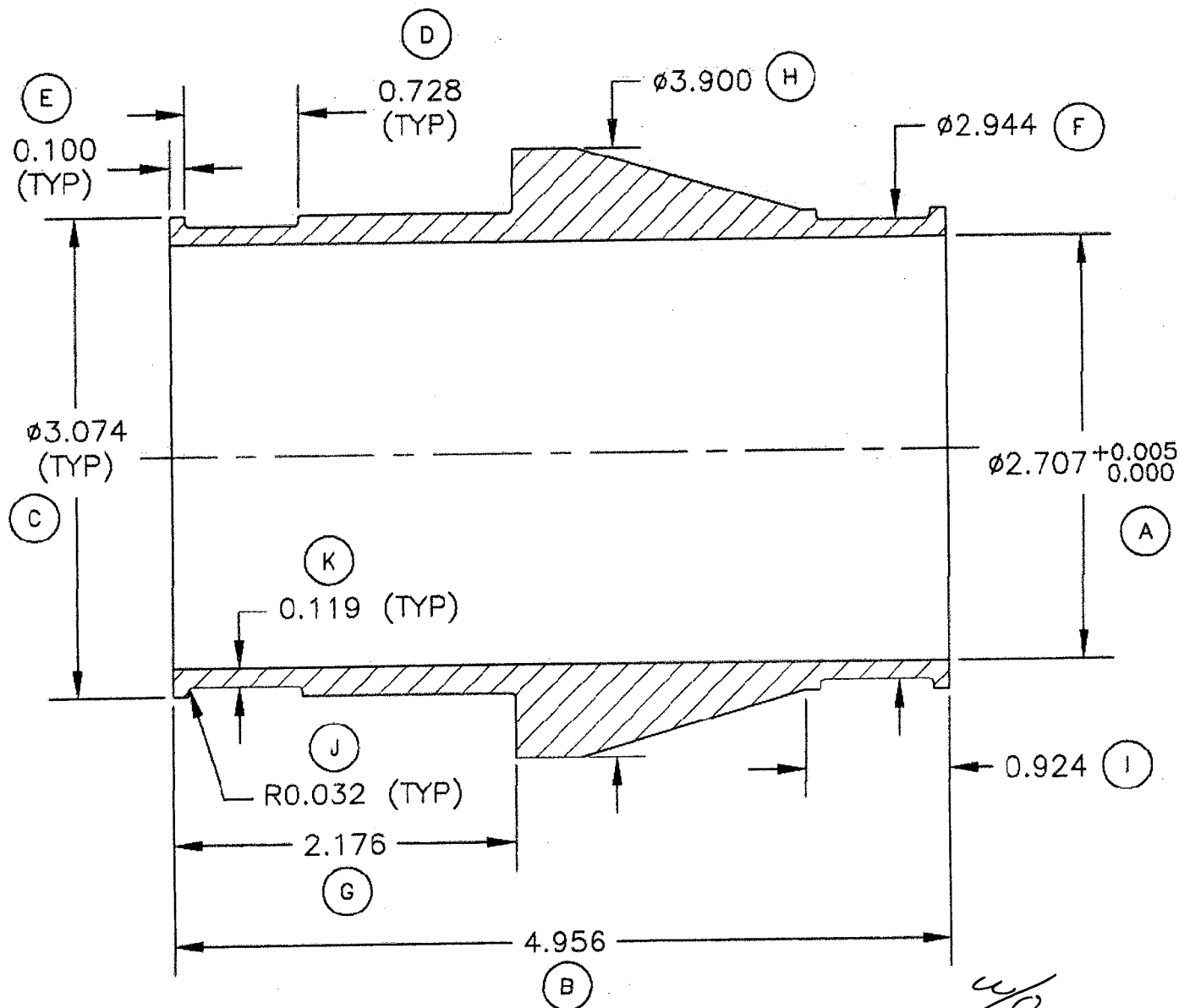
Measured by: <i>ml</i>	Date: 11.2.8
Audited by: <i>ml</i>	Date: 11/02/01
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	08.04.22	New Issue	KJ/JLM	<i>[Signature]</i>



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED  
# 03.07.01



D2893-1 TURNING DETAIL

u/p 66248

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